oerlikon
fairfield

Brake Service Manual – FBH05 Dry Series

Installation, Maintenance and Spare Parts Instructions

Model: Standard 'D' Mount (FBH05555-D) Series

Spring Applied, Hydraulically-Released Multiple Plate Brake for Dry Operation.

PRE-INSTALLATION CHECKS.

Mechanical.

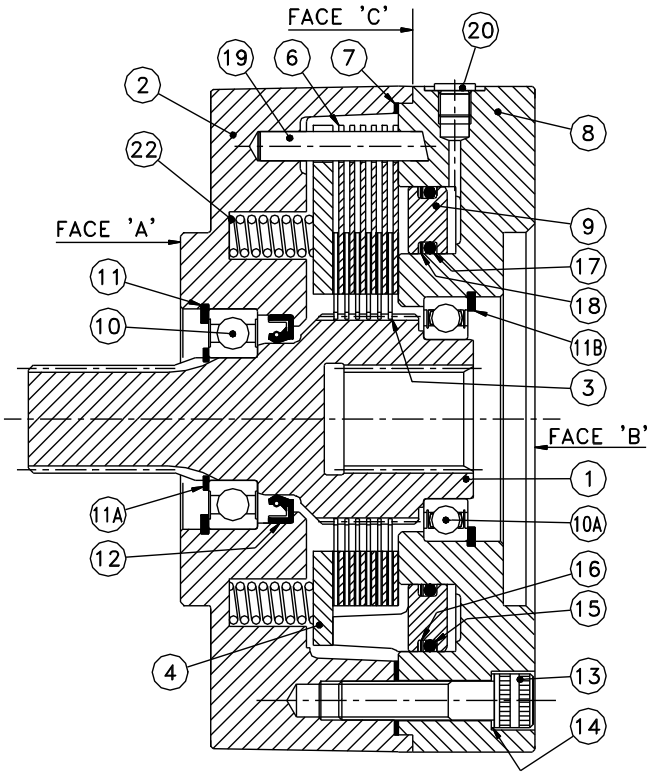
Check, that in the process of unpacking the brake and subsequent handling prior to assembly, the mounting features and other parts of the brake are undamaged. Ensure that the shafts to which the brake is mounted are clean and free from burrs and swellings.

Hydraulic/Mechanical.

To check brake release, connect an appropriate hydraulic pressure supply set to the required level up to a maximum of 3000 psi (200 bar) and check that brake shaft (1) is free to rotate.

Remove hydraulic supply from brake, checking to ensure that the friction plates (3 & 6) have engaged thus preventing rotation of brake shaft (1).

Important, release pressure during bench testing should be limited to 2000 psi (138 bar) unless brake is fully installed using 4-off ¾" UNC mounting bolts in the through (mounting) holes.



Item	Part No.	Description	Qty
1	DHB-1000	Brake Shaft	1
2	DHB-1300	Housing	1
3 ᶜ꜀	DHB-1900	Inner Friction Plate	6
4 ᶜ꜀	DHB-1400	Pressure Plate	1
5 ᶜ꜀	900507	Gasket	2
6 ᶜ꜀	DHB-1600	Outer Plate	6
7 ᶜ꜀	DHB-1500	Gasket	1
8	DHB-1100	Cylinder	1
9	DHB-1200	Piston	1
10 ᶜ꜀	SO02043	Deep Groove Ball Bearing	1
10A ᶜ꜀	SO01911	Deep Groove Ball Bearing	1
11	SO01155	Internal Retaining Ring	1
11A	SO01207	External Retaining Ring	1
11B	SO01105	Internal Retaining Ring	1
12 ᶜ꜀	SO01541	Rotary Shaft Seal	1
13	SO08539	Socket Head Cap Screw	4
14	SO09202	Shakeproof Washer	4
15 ᶜ꜀	SO01683	'O' Ring	1
16 ᶜ꜀	SO02488	Backing Ring	1
17 ᶜ꜀	SO02440	'O' Ring	1
18 ᶜ꜀	SO02535	Backing Ring	1
19	SO09517	Dowel Pin	2
20	SO09015	Hexagon Plug	1
21	SO09019	Plastic Plug	1
22 ᶜ꜀	CHB-1701	Outer Spring	♦
23 ᶜ꜀	CHB-1702	Inner Spring	♦

♦ Quantity of compression springs (items 22 & 23) will vary, depending upon the brake model used. (see chart on sheet 4 for further information).

Items marked thus ᶜ꜀ are recommended spares. Item 5 is an accessory kit supplied with each brake.

See over for Maintenance Instructions

Installation, Maintenance and Spare Parts Instructions
Model: Standard 'D' Mount (FBH05555-D) Series
Spring Applied, Hydraulically-Released Multiple Plate Brake for Dry Operation.

Installation.

Position 1-off gasket (5) over male pilot on brake housing (4).
Locate brake shaft (1) and secure brake in position using 2-off ¾" UNC mounting bolts in the through mounting (fixing) holes provided.
Connect hydraulic pressure supply to brake pressure inlet port. Ensure that the hydraulic pressure is set to the required level up to a maximum of 3000 psi (200 bar) and check that the brake disengages and re-engages correctly.

Maintenance.

The brake is required to be kept in good working order and must be included in the planned maintenance program for the equipment to which the brake is installed. This must include torque testing together with inspection and replacement of the working parts such as friction plates (3 & 6) and, springs (22 & 23). The frequency of inspection depends on the duty demanded of the brake.

Dismantling (and dis-assembly).

To remove brake from its installed position, reverse procedure previously described in the **Installation** instructions.
Place the complete brake assembly on a clean, dry workbench.

Remove external gaskets (5) as necessary.

REFER TO DIAGRAMS FOR THE FOLLOWING.

1) Supporting brake on face 'A', remove the four socket head cap screws (SHCS) and washers (items 13 & 14) in equal increments to ensure the spring pressure within the brake is reduced gradually and evenly. Alternatively, if a press is available, the cylinder housing (8) can be restrained on face 'B' while removing the four SHCS and washers (13 & 14). The brake assembly can now be fully dismantled and the parts examined.
2) Remove cylinder housing (8) and piston (9) sub-assembly and dismantle if required, removing 'O' ring seals (15 & 17) and backing rings (16 & 18) as necessary. Bearing (10A) can be pressed out after first removing internal retaining ring (11B).
3) Remove gasket (7) from housing (2).
4) Remove friction plates (3 & 6) and pressure plate (4). **Important:** Friction faces must not come into contact with oil or grease as this will seriously reduce the brake torque capacity.
5) Remove 2-off dowel pins (19).
6) Remove springs (22 & 23). **Note:** See chart on page 4 for spring arrangement and quantities for the particular brake model used.
7) Should it be necessary to replace ball bearing (10) or shaft seal (12), reverse remainder of brake sub-assembly, supporting on face 'C' of housing (2).
8) Remove retaining rings (11 & 11A).
9) Using arbor press or similar to break 'Loctite' seal, remove brake shaft (1) from housing (2) and lay aside.
10) Reverse housing (2) and press out ball bearing (10). Shaft seal (12) can also be removed if necessary.

Examination.

All components can now be examined and inspected, paying particular attention to the following.

1) Inspect friction plates (3 & 6) and friction surface on pressure plate (4) for wear or damage.
2) Examine friction plates (3) and brake shaft (1) for wear or damage to the splines.
3) Examine input and output splines of brake shaft (1) for wear or damage.
4) Examine compression springs (22 & 23) for damage or fatigue.
5) Check ball bearing (10 & 10A) for axial float or wear.
6) Examine 'O' ring seals (15 & 17) and backing rings (16 & 18) for damage.

OBTAIN REPLACEMENT PARTS AS REQUIRED.

Assembly.

Clean all parts thoroughly.
Reverse procedure previously outlined in **Dismantling** instructions taking particular care with.
a) Assembly of shaft seal (12).
b) Assembly of bearing (10).
c) Quantity and orientation of springs (22 & 23). **Note:** See chart on back page for spring quantities and arrangement for the particular brake model used.
d) Assembly sequence of friction plates (3 & 6). - See diagram.

1) Lightly lubricate rotary shaft seal (12) and assemble to housing (2) taking care not to damage seal lip.
2) Apply ring of Loctite 641 or equivalent adhesive to full circumference of housing (2) bearing recess adjacent to shoulder.
   Apply complete coverage of Loctite 641 to outside diameter of bearing (10) and assemble fully in housing (2), retaining with internal retaining ring (11). Remove excess adhesive with a clean cloth.
   Secure and seal bearing inner ring to shaft (1) using Loctite 641 applied to bearing inner diameter, retaining with external retaining ring (11A). Remove any excess adhesive with a clean cloth.

Installation, Maintenance and Spare Parts Instructions

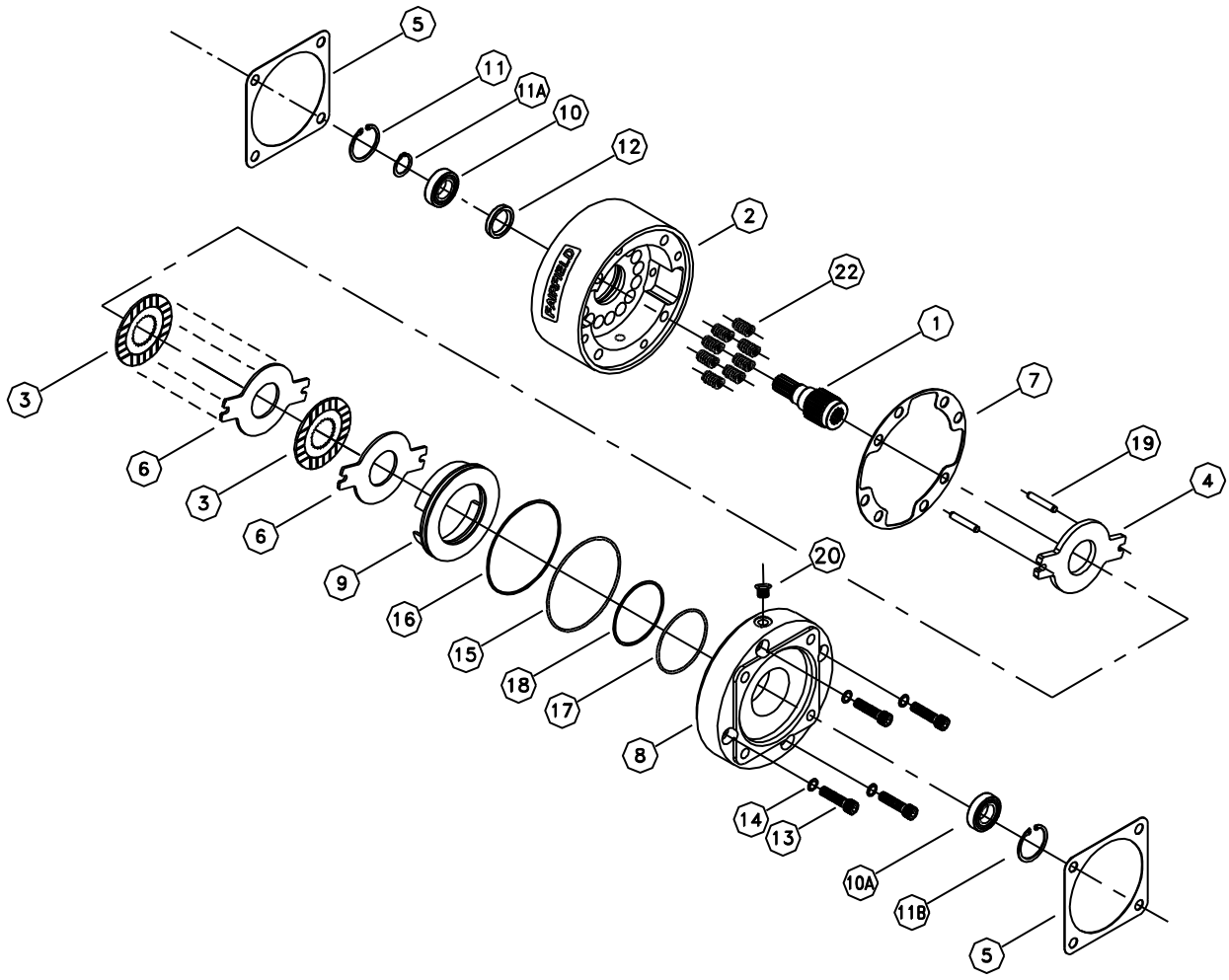
Model: Standard 'D' Mount (FBH05555-D) Series

Spring Applied, Hydraulically-Released Multiple Plate Brake for Dry Operation.

3) Assemble correct quantity of springs (22 & 23) in orientation required.
4) Lubricate 'O' ring seals (15 & 17) with Molykote 55M (or equivalent) silicon grease and assemble together with backing rings (16 & 18) to piston (9). To ensure correct brake operation, it is important that the backing rings are assembled opposite to the pressurized side of piston (9).
5) Apply complete coverage of Loctite 641 to outside diameter of bearing (10A) and press in to recess in cylinder (8). Assemble internal retaining ring (11B).
6) Correctly orientate piston (9) aligning spaces with the two dowel pin holes and, assemble into cylinder housing (8) taking care not to damage seals and carefully lay aside.
7) Locate 2-off pins (19) in housing (2) followed by pressure plate (4) and friction plates i.e. an inner (3) followed by an outer (6) in correct sequence.
8) Position gasket (7) in correct orientation.
9) Align two holes in cylinder with dowel pins (19) and assemble piston & cylinder sub-assembly to remainder of brake securing with 6-off SHCS and washers (13 & 14). Torque tighten to 90 lbF.ft (120 Nm).

Note: The use of a suitable press (hydraulic or arbor) pressing down on cylinder end face 'B' will ease assembly of the SHCS (13).

<u>Note:</u> If new friction plates have been assembled, it is recommended that the friction faces are "bedded in" to help ensure stable torque performance.



Installation, Maintenance and Spare Parts Instructions
Model: Standard 'D' Mount (FBH05555-D) Series
Spring Applied, Hydraulically-Released Multiple Plate Brake for Dry Operation.

SPARES KITS.

a) **Friction Disc Kit FDHB0000-SK1** comprising
- 1-off pressure plate (item 4)
- 1-off gasket (item 7)
- 6-off outer plates (item 6)
- 6-off inner plates (item 3)

b) **Spring Kit FDHB0000-SK2** comprising
- 18-off outer springs CHB-1701 (item 22)

c) **Spring Kit FDHB0000-SK3** comprising
- 4-off inner springs CHB-1702 (item 23)

d) **Seal Kit FDHB0000-SK4** comprising
- 1-off gasket (item 7)
- 1-off 'O' ring (item 15)
- 1-off backing ring (item 16)
- 1-off 'O' ring (item 17)
- 1-off backing ring (item 18)
- 2-off gaskets (item 5)

e) **Bearing Kit FDHB0000-SK5** comprising
- 1-off gasket (item 7)
- 1-off bearing (item 10)
- 1-off bearing (item 10A)
- 1-off rotary shaft seal (item 12)
- 1-off internal retaining ring (item 11)
- 1-off external retaining ring (item 11A)
- 1-off internal retaining ring (item 11B)

CHART OF SPRING OPTIONS.

Note: Two types of springs are incorporated in the FBH05-D Series Brakes, CHB-1701 (outer spring) & CHB-1702 (inner spring).

Brake Model	Quantity of CHB-1701 inner springs.	Quantity of CHB-1702 outer springs.	Initial Release Pressure (psi)	Full Release Pressure (psi)
FBH0555570D	8	4	65	85
FBH0555580D	10	2	75	95
FBH0555590D	12	-	85	105
FBH05555100D	12	4	95	120
FBH05555110D	14	2	103	130
FBH05555120D	16	-	112	140
FBH05555130D	16	4	123	155
FBH05555140D	18	2	130	165

Other models are available. Consult Fairfield Manufacturing Company, Inc. for further information.